



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D412-742-043
Job Sheet 175925



Part No: D412-742-043

Job Qty: 1 ea

Part Name: Repl. Skidtube Fits LH or RH, High Gear, DART (Apical) Tri-Bag Float Comp.



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 4/12/18

Job Tracking No:

Due Date: 5/21/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG D3391-043 REV J SHEETS 1,2 IPP Rev A 05.10.13 New Issue KJ/JLM IPP Rev 06.02.13 ECN 773 dwg
@ rev.D EC IPP Rev:C 07-05-28 As per Rev F JLM IPP Rev:D 07-12-04 ECN 1072 DD verified by:JLM IPP
Rev:E 08-09-08 ecn 08-510 DD verified by:EC IPP Rev:F 11.11.01 as per DSI9517 REV.B DD verified by:EC
IPP REV:G 16.05.02 AS PER DWG REV.J DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		5/19/18	0.00	0.00	Start Up Container		M 12-08-20
110	HandFinish	1 pcs		5/21/18	0.00	3.50	HandFinish4		M 12-08-20
120	QC	1 pcs		5/21/18	0.00	0.00	QC5		AUG 21 2018 38
125	DC	1 pcs		5/21/18	0.00	0.00	DC		AUG 24 2018 9-89
130	Packaging	1 pcs		5/21/18	0.00	0.00	Packaging3-2		DAS 21 9-89
140	QC21-FG	1 Ea		5/21/18	0.00	0.00	QC21		AUG 24 2018

Part Op 110 - 1-Install tubes together and seal them all the way around using Sikaflex 241/291. Ensure tube ends line-up with
Descriptions: saddle holes for proper alignment. using 7/16" "T" Pins. A/R Sikaflex-241/-291 1138974 Expiry date: 19109
19109 2-Install wearplates as per Dwg D3391. Ensure that plastic washers are against wearplate, then topped
with the SS washer. Seal all bolts with sikaflex except ones with inserts on inside of tube ,hand tighten only bolts with no
sikaflex. A/R Sikaflex-241/-291 1138974 Expiry date: 19109 3-Remove "T" pins once sikaflex is dry.
4-Coat all exposed hardware with LPS Procyon. Remove any excess off with MEK degreaser. A/R LPS Procyon
VERIFY FWD AND AFT SADDLE FIT DURING ASSEMBLY BY: 18-8-20
125 - If D412-742-043 is a W/O on it's own, Photocopy bluefile and create labels per PPP D412-742-043 CHG007
130 - Identify and pack for shipping as per PPP D412-742-043 Location: _____ PPP Rev: _____

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
AN3C4A	Bolt	24 Ea (24 ea)	90-Start up Operation	5060051
AN3C6A	Bolt	4 Ea (4 ea)	90-Start up Operation	5076000
AN5C7A	Bolt	10 Ea (10 ea)	90-Start up Operation	5076003
D3391-021	Fwd Tube Assembly	1 Ea (1 ea)	90-Start up Operation	5064635
D3391-023	Mid Tube Assembly	1 Ea (1 ea)	90-Start up Operation	5075913
D3391-025	Aft Tube Assembly	1 Ea (1 ea)	90-Start up Operation	5063150
D4095-041	Wearplate Fwd	1 Ea (1 ea)	90-Start up Operation	5006063
D4095-043	Wearplate Aft	1 Ea (1 ea)	90-Start up Operation	5059995
D4095-045	Wearplate Center	1 Ea (1 ea)	90-Start up Operation	5072836
NAS1149C0332R	Washer	28 Ea (28 ea)	90-Start up Operation	5071663
NAS1149C0532R	Washer	10 Ea (10 ea)	90-Start up Operation	5014735

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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OTHER : _____																					

90-Start up Operation

AN3C4A	24	2,377	0
AN3C6A	4	294	0
AN5C7A	10	152	0
D3391-021	1	2	0
D3391-023	1	3	0
D3391-025	1	1	0
D4095-041	1	11	0
D4095-043	1	14	0
D4095-045	1	10	0
NAS1149C0332R	28	6,679	0
NAS1149C0532R	10	397	0

Part Specifications

Specifications could not be found.

DART
AEROSPACE

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Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Plex 4/12/18 11:42 AM Dart.lajeunesse.marie

Container No: S103641



Part: D412-742-043

Job No: 175925

Serial No/Batch: S103641

Revision: A/J

Inspector:

Exp Date:

Instructions: FAA STC SR01583SE 15/10/20, TSO STC SH05-37 Issue 1, EASA ST

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

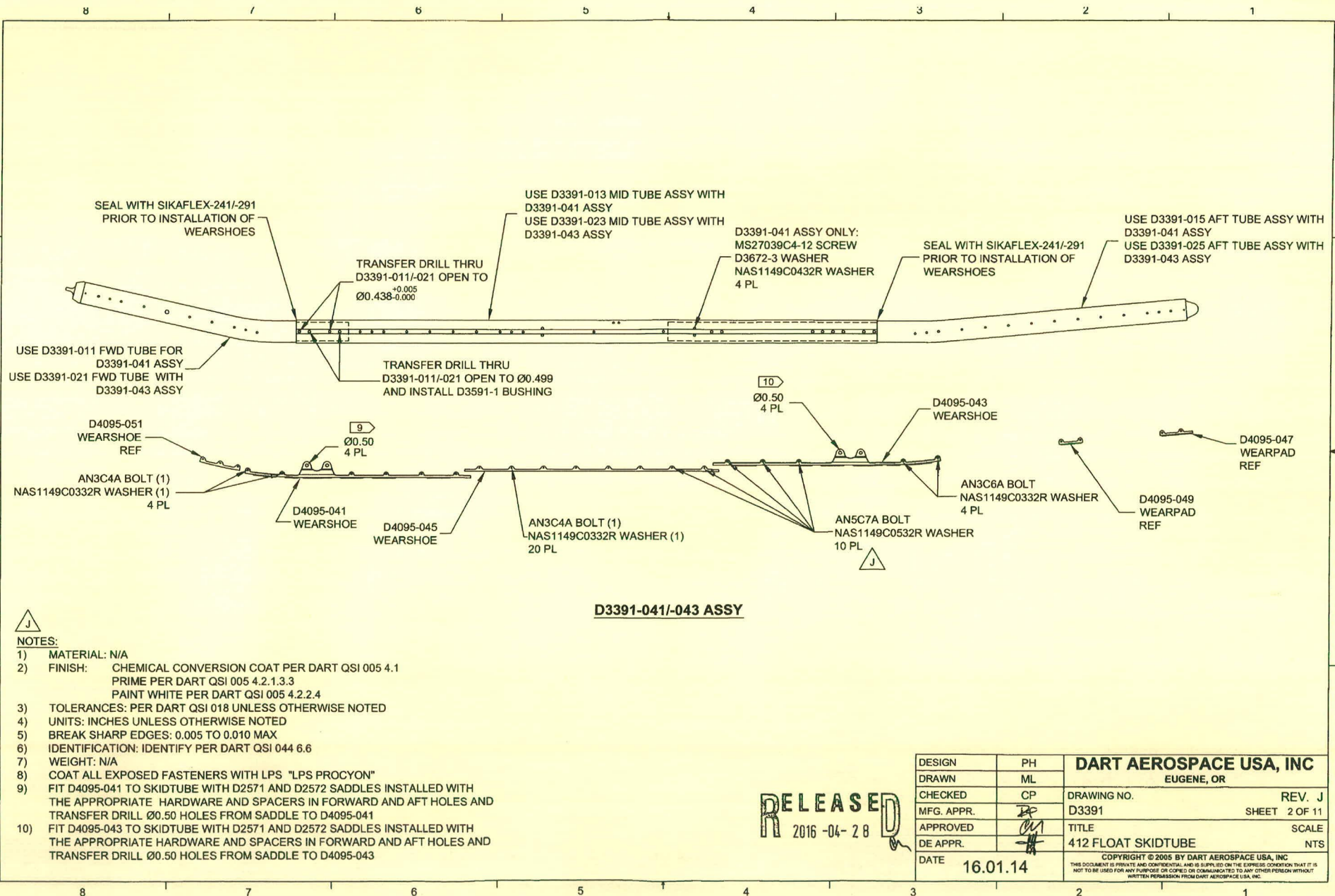
Work Order update only ☐

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Date : _____	Step #: _____	QTY Effective : _____	MRB (QSI042) Approval
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Description Work Order Deviation	Disposition	Completed By
		Lead hand / Supervisor Approval Verification
		QC / QA Coordinator Approval

Root Cause <table> <tr> <td>Environment ☐</td> <td>No Re-verification ☐</td> <td>Pressure/Forced ☐</td> </tr> <tr> <td>Design ☐</td> <td>Operator ☐</td> <td>Bending ☐</td> </tr> <tr> <td>Doc/Data ☐</td> <td>Offset/Setup ☐</td> <td>Centre Not Concentric ☐</td> </tr> <tr> <td>Equip/Tooling ☐</td> <td>Supplier ☐</td> <td>Cracks ☐</td> </tr> <tr> <td>Handling/Pre ☐</td> <td>Training ☐</td> <td>Crimp/Kink/Ripple/Wave ☐</td> </tr> <tr> <td>Material ☐</td> <td>Use for Testing ☐</td> <td>Cuffs ☐</td> </tr> <tr> <td>Internal Transport ☐</td> <td>Poor Information ☐</td> <td>Crushing ☐</td> </tr> <tr> <td>Tribal Knowledge ☐</td> <td>Rushing ☐</td> <td>Heat Treat ☐</td> </tr> <tr> <td>LOA ☐</td> <td>Product Improvement ☐</td> <td>Wave/Twist in Tube ☐</td> </tr> <tr> <td>Substation ☐</td> <td>Process Improvement ☐</td> <td>Marks/Chatter ☐</td> </tr> <tr> <td>Past Expiry Date ☐</td> <td>Manufacturing Process ☐</td> <td></td> </tr> <tr> <td>Misidentified ☐</td> <td>Past Due ☐</td> <td></td> </tr> </table>			Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Design ☐	Operator ☐	Bending ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Past Expiry Date ☐	Manufacturing Process ☐		Misidentified ☐	Past Due ☐		FAULT CATEGORY <table> <tr> <td>Temperature/Cure ☐</td> <td>Power Loss/Surge ☐</td> <td>Positioned Wrong ☐</td> </tr> <tr> <td>Set-up ☐</td> <td>Folio/Program ☐</td> <td>Outside Dimensions ☐</td> </tr> <tr> <td>BOM/Route ☐</td> <td>Grain ☐</td> <td>Over/Under tolerance ☐</td> </tr> <tr> <td>Broken/Damage/Defect ☐</td> <td>Weld ☐</td> <td>Part Incorrect ☐</td> </tr> <tr> <td>Inspection Incomplete/Unqualified ☐</td> <td>Wrong Stock Pulled ☐</td> <td>Part Lost/Missing ☐</td> </tr> <tr> <td>Contamination ☐</td> <td>Out of Sequence ☐</td> <td>Part Moved ☐</td> </tr> <tr> <td>Countersink ☐</td> <td>Off-set ☐</td> <td>Drawing ☐</td> </tr> <tr> <td>Cut Too Short ☐</td> <td>Mislabeled ☐</td> <td>Finish ☐</td> </tr> <tr> <td>Instructions Incomplete/Unclear ☐</td> <td>Fit/Function ☐</td> <td>Misread ☐</td> </tr> <tr> <td>Drill Holes ☐</td> <td>Misaligned/off center ☐</td> <td>Turning Sequence ☐</td> </tr> </table>			Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Countersink ☐	Off-set ☐	Drawing ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
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RELEASED
2016-04-28

DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	ML	EUGENE, OR	
CHECKED	CP	DRAWING NO.	REV. J
MFG. APPR.	DP	D3391	SHEET 2 OF 11
APPROVED	DP	TITLE	SCALE
DE APPR.	DP	412 FLOAT SKIDTUBE	NTS
DATE	16.01.14	COPYRIGHT © 2005 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

